

Work Order ID 84840

84840

Page 1

May-24-12 7:57:45 AM

Item ID: D206-642-341

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 24/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/28 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2650

F

100

0.00

100

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod *m120164*

4-Grind weld flush to cap on top surface only.

5-Cut aft end to length as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

*BE 12/05/29**CF 12-6-8*

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	QC5- Inspect part completeness to step on W/O	0.00							
115									
QC	Memo	0.00							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00							
Hand Finishing									
125	QC7-Inspect Chemical Conversion Coat	0.00							
125									
QC	Memo	0.00							
Quality Control									

①

~~12-06-07~~
CF

①

SAD 12-06-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs.
cure time before cuttingStart Date: 12-6-12 Time: 16:00Finish Date: 12-06-12 Time: 4:00A/RSikaflex-291 M121009Sikaflex expiry date: 13-4-12

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

CF 12-6-12

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/RAluminum Rod *m120164*

86 12/06/12

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

DP12-6-12

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

SAD 12-06-12

4- Install nut plate as per dwg

DP12-6-12

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

8726414

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

8 or below

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1 26 12-6-14

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*7:30
320°F
8:00*

1X 4 12/06/15

W121134

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

1x 4 11 110614

W/O:		WORK ORDER CHANGES					
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Start Date: 24/05/2012 Start Qty: 1.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

0.00

220

HandFinish

HandFinishing

0.00

Hand Finishing

Memo

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/RSikaflex-291 121409Sikaflex expiry date: 13/03

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/RSikaflex-291 121409Sikaflex expiry date: 13/03

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: 1216131 2 JP 12/06/19

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

8.7 hrs/20

Quality Control

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

8.7 hrs/20

Quality Control

250

Packaging

0.00

250

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-642-341

Location:

PPP Rev:

PP84833

6/12/12 9 0

W/O:		WORK ORDER CHANGES					
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Stop ***NR2***Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00

260

QC

Memo

0.00

Quality Control

OK 12/7/12

D20741

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

84840

D206-642-341

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD416 *AN960JD416* Washer	NAS1149D0463J	Purchased	No		121912		Each	30.0000	**	1		12/06/12	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST351			30						
				116289			10						
				119097			20						
CCR264SS3-3 *CCR264SS3-3* Cherry Rivet		Purchased	No				Each	364.0000	**	2		12-6-12	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST331			364						
				113973			2						
				117849			81						
				119017			281						
CR3212-4-03 *CR3212-4-03* Cherry Rivet		Purchased	No				Each	1,278.000	**	2		12-6-12	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				FP002			350						
				114859			350						
				ST331			928						
				110139			2						
				119017			926						

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Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2620

Manufactured No

Each

17.0000

1

D2620

Skidtube, 206 Skidtube

**

BE 12/05/29

Location

Loc Qty

Loc Code

LG

17

79543

2

79544

1

81365

1

82517

3

82518

10

1

D2647

Manufactured No

Each

79.0000

1

D2647

Cap

**

BE 12/05/29

Location

Loc Qty

Loc Code

LG002

79

75482

3

79563

76

W/O:		WORK ORDER CHANGES					
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D206-642-341

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

Each

415.0000

19

D2649

Cross Bolt Spacer

**

BE 12/06/12

Location

Loc Qty

Loc Code

LG

272

77574

2

79502

8

79503

251

79564

4

79565

7

LG001

143

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

79566

16

19

D2654-5

Manufactured No

Each

1.0000

1

D2654-5

Web

**

① CF 12.67

Location

Loc Qty

Loc Code

LG

1

82128

1

B85209

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Shop Packet Print

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D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

Each

87.0000

D2680-041

Nut Plate

**

1 **DP** 12-6-12

Location

Loc Qty

Loc Code

ST013

87

78016

87

Each

1,733.000

**

2 **DP** 12/06/19

MS27039-1-08

Purchased No

MS27039-1-08

Screw

Location

Loc Qty

Loc Code

ST291

1733

117423

81

119075

1

120308 ✓

594

121011

57

121243

500

121708

500

Each

1,022.000

**

54

54 **DP** 12/06/19

MS27039C1-08

Purchased No

MS27039C1-08

SCREW

Location

Loc Qty

Loc Code

FP002

1

116022

1

ST292

1002

120308

354

121068

108

121162 ✓

540

ST293

19

116373

3

118077

14

119309

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-24-12 7:57:49 AM

Page 5

Work Order ID: 84840

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

84840

D206-642-341

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

220

Each

3,051.000

54

54

AI S4-1032-130

Insert

**

54

SP

12/06/19

Location

Loc Qty

Loc Code

ST280

205

119084

116

120671

89

ST281

124

120807

36

120837

88

ST282

2722

121269

2722

AN960C10L

*

NAS1149C0332

Purchased

No

220

Each

0.0000

54

54

*AN960C10I *

washer

AN960JD10L

*

NAS1149D0332J

Purchased

No

220

Each

0.0000

2

2

*AN960.ID10I *

Washer

D2646

Manufactured

No

220

Each

32.0000

1

1

D2646

Aft Cap

**

54

SP

12/06/19

**

2

SP

12/06/19

**

1

SP

12/06/19

Location

Loc Qty

Loc Code

FP002

32

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

4

79562

12

May-24-12 7:57:50 AM

Shop Packet Print

Page 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-24-12 7:57:50 AM

Page 6

Work Order ID: 84840

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

84840

D206-642-341

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

220

Each

439.0000

14

14

D2651-1

Plug

**

14

12/06/19

Location

Loc Qty

Loc Code

FP

200

FP001

425

57869

1

66445

10

69018

2

70827

2

70839

8

71037

8

77559

30

78584

18

79234

46

FP-A

-186

77559

1

78124

5

81954

108

82573 ✓

200

D2651-3

Manufactured No

220

Each

1,246.000

14

14

D2651-3

O-Ring

**

14

12/06/19

Location

Loc Qty

Loc Code

FP001

16

61962

12

73828

4

FP-A

1230

78126 ✓

1230

May-24-12 7:57:50 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-24-12 7:57:50 AM

Page 7

Work Order ID: 84840

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

84840

D206-642-341

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-11

Manufactured No

220 Each

16.0000 1 1

D3535-11

Wearshoe

**

1 (28) 12/06/19.

Location

Loc Qty

Loc Code

FP001

16

82153 ✓

16

D3535-23

Manufactured No

220 Each

18.0000 1 1

D3535-23

Wearshoe

**

1 (28) 12/06/19.

Location

Loc Qty

Loc Code

FP001

18

81355

1

83375 ✓

17

D3535-35

Manufactured No

220 Each

30.0000 1 1

D3535-35

Wearshoe

**

1 (28) 12/06/19.

Location

Loc Qty

Loc Code

FP001

30

67598

1

70815

1

78873

13

79849

1

82064

1

83638 ✓

13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-24-12 7:57:50 AM

Page 8

Work Order ID: 84840

84840

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-11

Manufactured No

220 Each

16.0000 1 1

D3536-11

Gasket

**

1

(DP) 12/06/19

Location

Loc Qty

Loc Code

FP002

16

46649

1

46715

4

65574

1

80006

1

82152 ✓

9

D3536-23

Manufactured No

220 Each

12.0000 1 1

D3536-23

Gasket

**

1

(DP) 12/06/19

Location

Loc Qty

Loc Code

FP002

12

74510

1

83377

11

D3536-35

Manufactured No

220 Each

17.0000 1 1

D3536-35

Gasket

**

1

(DP) 12/06/19

Location

Loc Qty

Loc Code

FP002

17

81340 ✓

6

82065

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-24-12 7:57:50 AM

Page 9

Work Order ID: 84840

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

84840

D206-642-341

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No

220

Each

79.0000

6

6

D3537-1

Wearpad

**

6

DP

12/06/19

Location

Loc Qty

Loc Code

FG

83256 ✓

10

79833

10

FP002

69

69817

5

81360

38

81362

22

83254

1

83255

3

D3537-3 Manufactured No

220

Each

24.0000

1

1

D3537-3

Wearpad

**

1

DP

12/06/19

Location

Loc Qty

Loc Code

FP002

24

78836

3

81363 ✓

21

MS27039-4-06 Purchased No

220

Each

131.0000

1

1

MS27039-4-06

Screw

**

1

DP

12/06/19

Location

Loc Qty

Loc Code

ST292

131

119075 ✓

131

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID-PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 84840 MCT

12/05/28

RELEASED
08.07.23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL. ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

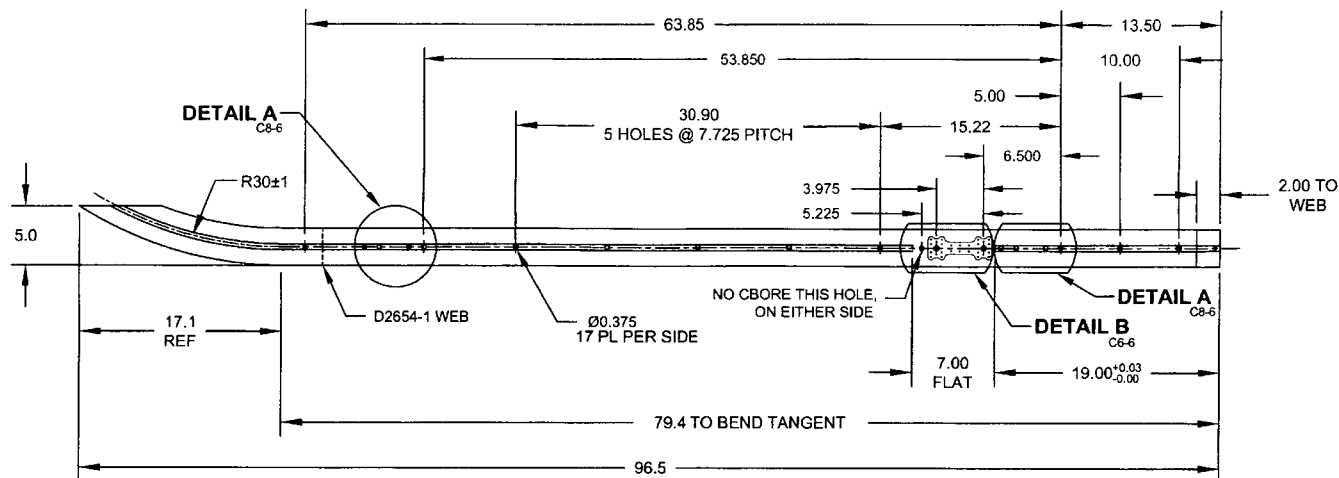
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

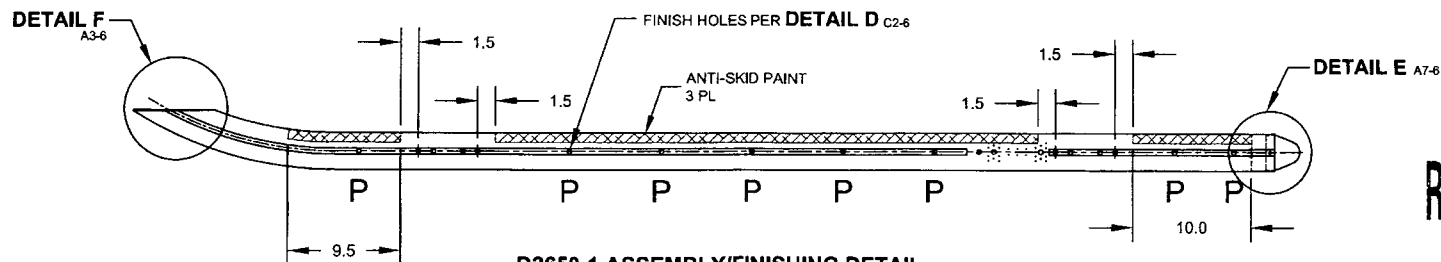
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

RELEASED
88 07 22 100

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
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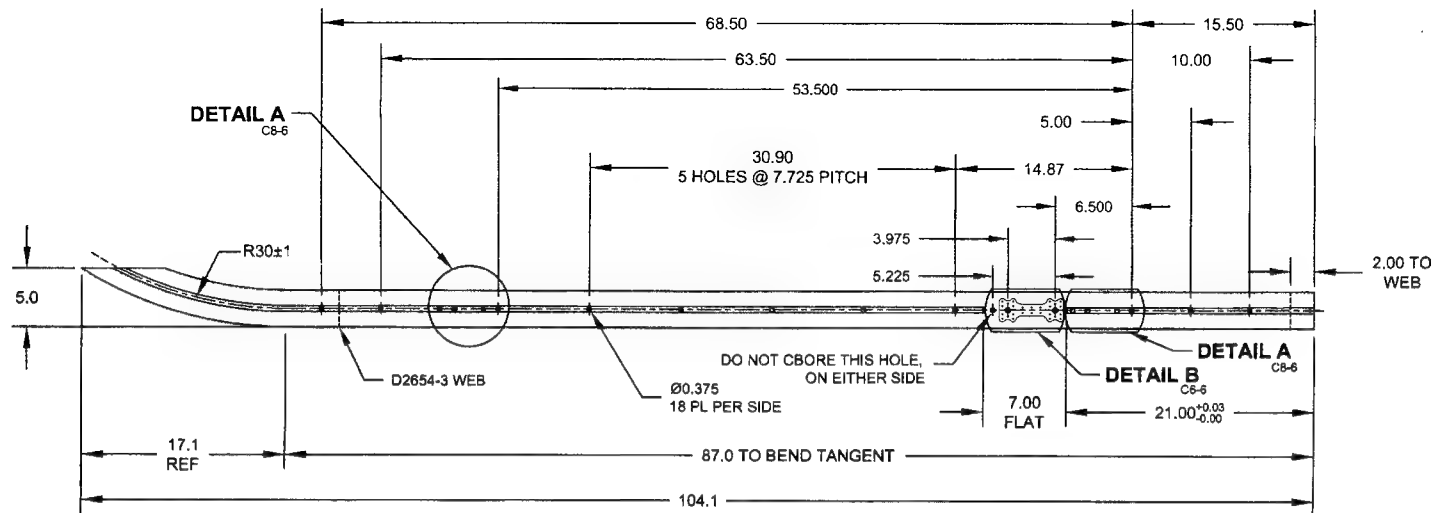
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

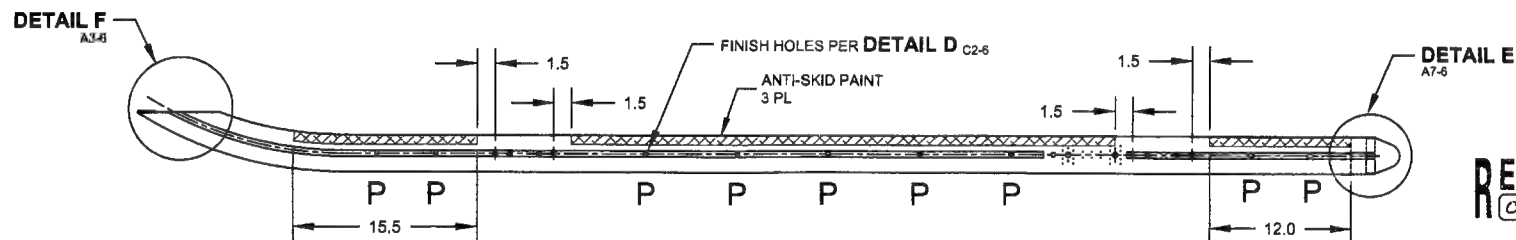
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

RELEASED
08-07-22/188

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL F A3-6

1.5

9.5

P P P P P P P

FINISH HOLES PER DETAIL D C2-6

ANTI-SKID PAINT 2 PL

1.5

DETAIL E A7-6

RELEASE

RELEASED
JAN 22 1977

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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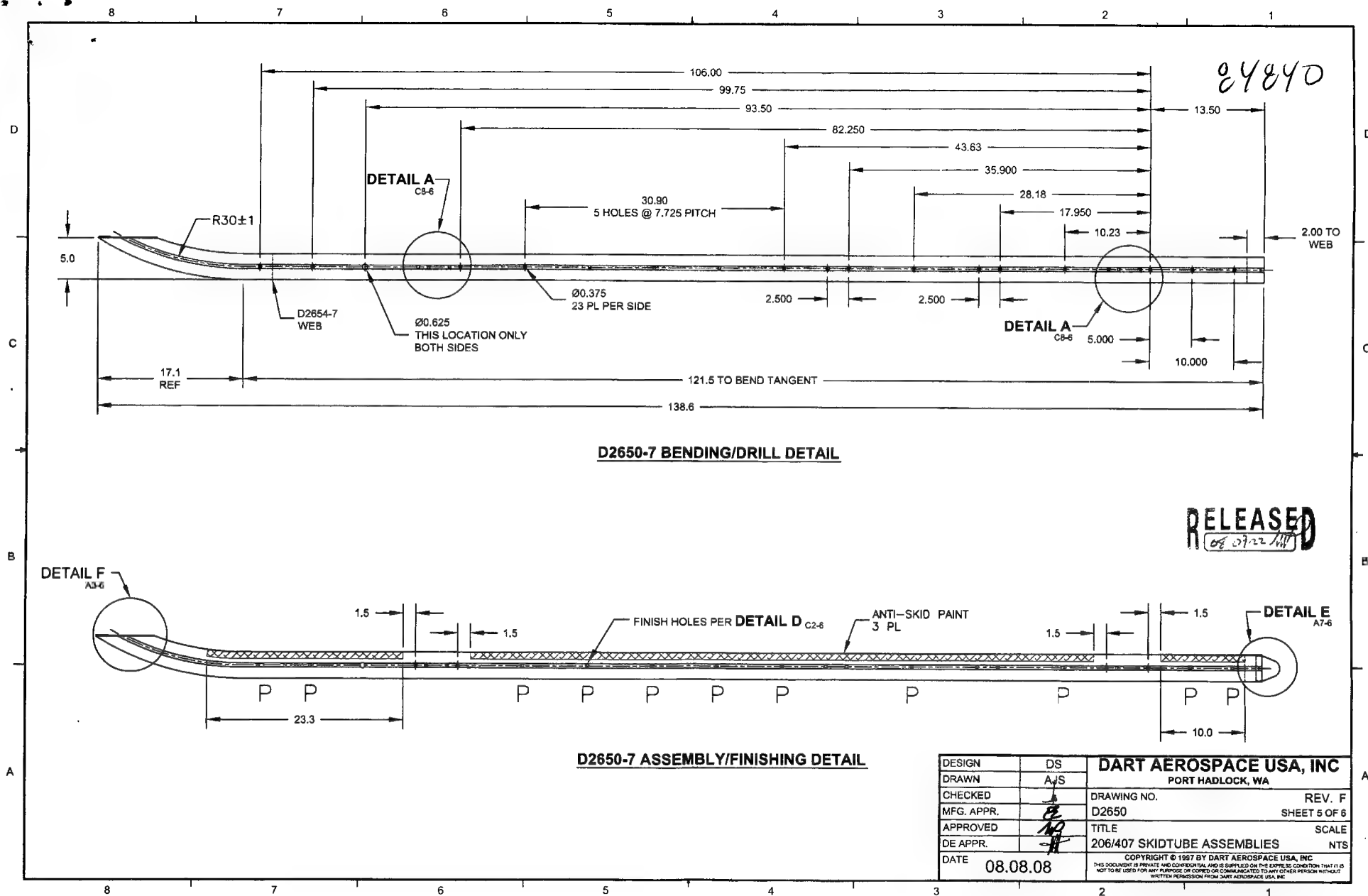
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



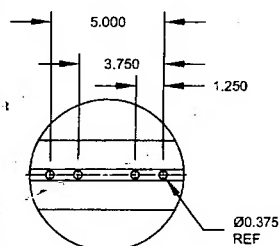
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

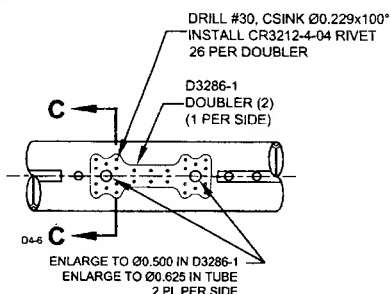
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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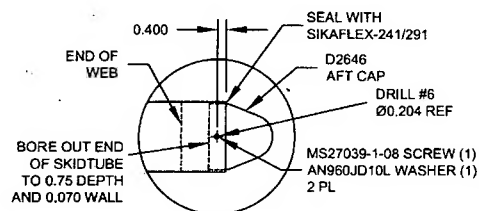
DETAIL A
SCALE 2X

C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D8-5



DETAIL B
SCALE 2X

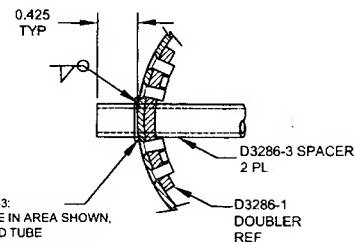
C3-2
C3-3



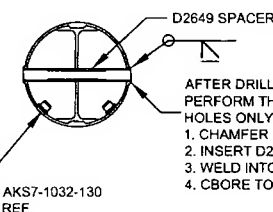
DETAIL E
SCALE 2X

B2-2
B2-3
B1-4
B1-5

SECTION C-C C7-6
SCALE NONE

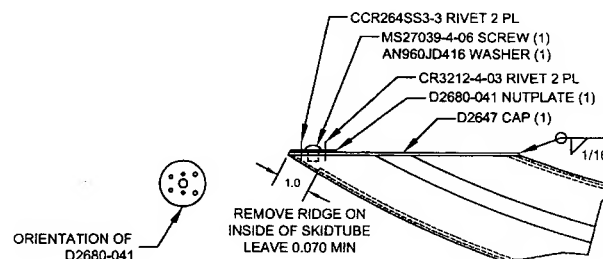


- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X

B4-2
B4-3
B4-4
B4-5



DETAIL F
SCALE NONE





B8-2
B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-09-22-18

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 297

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job #: 80951
Part #: A206-642-151
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[<input checked="" type="checkbox"/>]	fail[]
Incomplete Penetration:	pass[<input checked="" type="checkbox"/>]	fail[]
Incomplete Fusion:	pass[<input checked="" type="checkbox"/>]	fail[]
Cracks:	pass[<input checked="" type="checkbox"/>]	fail[]
Overlap (cold lap)	pass[<input checked="" type="checkbox"/>]	fail[]
Undercut:	pass[<input checked="" type="checkbox"/>]	fail[]
Pin holes:	pass[<input checked="" type="checkbox"/>]	fail[]
Porosity (surface):	pass[<input checked="" type="checkbox"/>]	fail[]
Coloration:	pass[<input checked="" type="checkbox"/>]	fail[]
Burn through:	pass[<input checked="" type="checkbox"/>]	fail[]

Qualifier [Signature] Date of Test Coupon 12.06.13
Welder Barday Elliott Date of Test Coupon 12.06.13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld